

In order to overcome this difficulty, an adjustable stop, as shown in Fig. 20, has been designed. The flat style of wedge is abandoned, and the wedge *A* is made of drill rod and slides in a hole drilled in the base of the fixture. The stud at the back end of the wedge is screwed into it instead of being riveted, as in the previous example. Bushing *C* is provided with a shoulder and a headless set-screw *D* is added to prevent plunger *E* from dropping out when the fixture is not in use. The wedge *A* is subjected to considerable friction and the fixture is, therefore, not so sensitive to the touch of the operator as would be desir-

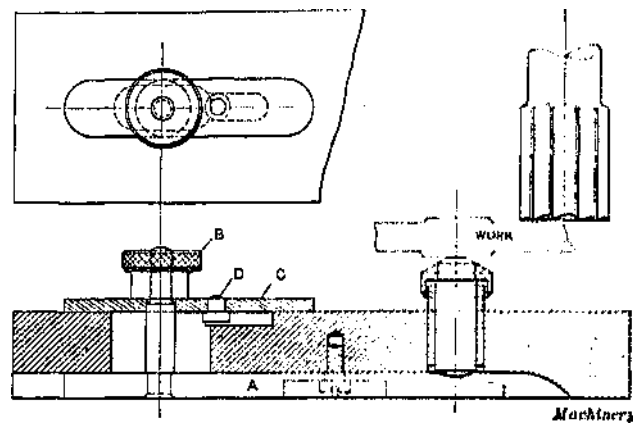


Fig. 19.

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able. It is difficult for the operator to feel when the

stop is against the work, when tightening the wedge in position.

Fig. 21 shows a modification of the design shown in Fig. 20, the only change made being in bushing *A*, which has been lengthened so that it will act as a support for the end of wedge *B*. The bushing is made of cold-rolled steel and casehardened. The bottom part of the base is cut away in order to reduce the friction between the base and the wedge. This design is better than that shown in Fig. 20.

In Fig. 22 is shown a somewhat complicated and expensive adjustable stop which, however, has the advantages of almost perfect operating conditions. Bushing *A* is lengthened and has